

Work Order ID 62770

October 7, 2010 3:40:45 PM



Page 1

Item ID: D2196-2

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 10/07/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/14/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: CL Date: 10/10/07 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2196	Rev C
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100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2196 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

304 . 063

IB 10-10-7

(3)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 10-10-7

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sidolo

(x3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Bend as per dwg D2196	0.00 0.00				②			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				3			10/10/18
150 Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00							10/11/18 SP 30

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Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 10/07/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/14/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/20

MF

10-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

October 7, 2010 3:40:45 PM

Page 1

Work Order ID: 62770

Parent Item: D2196-2

Parent Item Name: Bracket



Start Date: 10/07/10

Required Date: 10/14/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA		Purchased	No			100	sf	64.3100	0.211	0.444211			
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304/316 Sheet .063



17
136-10-7

Location

Loc Qty

Loc Code

MAT	58.47	
111323	0	
115688	58.47	
MAT20	5.84	
115440	5.84	

115688

13

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	62770
Description: Bracket		Part Number:	D2196-2
Inspection Dwg: D2196	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.130	X		V 1.302	
Ø0.203	+0.005/-0.001	.205	X		V	
Ø0.316	+0.006/-0.001	.317	Ø		V	
0.375	+/-0.010	.374	X		V	
0.813	+/-0.010	.812	X		V	
1.750	+/-0.010	1.748	X		V	
2.688	+/-0.010	2.688	X		V	
3.625	+/-0.010	3.624	X		V	
4.000	+/-0.010	4.002	Ø		V	
0.375	+/-0.010	.375	X		V	
1.200	+/-0.010	1.200	X		V	
2.390	+/-0.010	2.389	X		V	
3.960	+/-0.010	3.958	X		V	
5.530	+/-0.010	5.535	X		V	
6.730	+/-0.010	6.730	X		V	
7.230	+/-0.010	7.226	1			

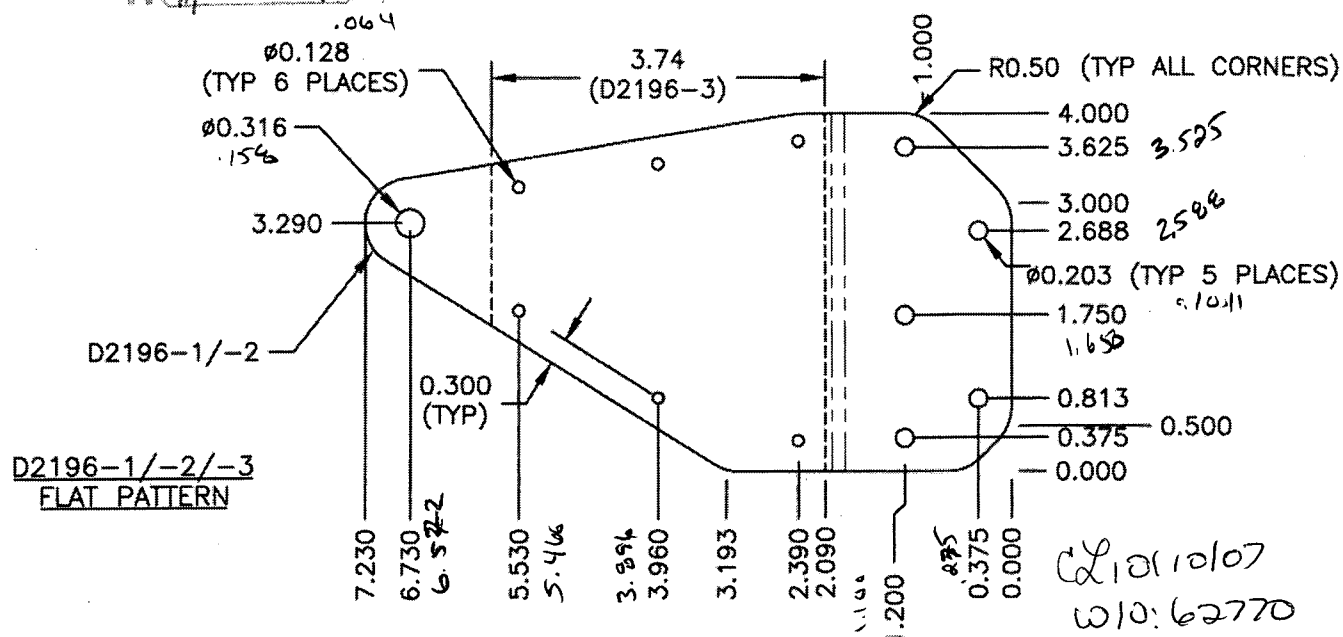
Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	10-10-7	Date:	10/10/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.08.27	New Issue	KJ/DD	



DESIGN #		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #		APPROVED #		DRAWING NO. D2196 REV. C SHEET 1 OF 1	
DATE 03.05.28			TITLE BRACKET SCALE 1:2		
B	93.09.23		REDESIGN		
C	03.05.28		REDRAW; D2196-3 NOW 0.5" THICK		

RELEASED
03-07-09



D2196-1/-2

- 1) MATERIAL: AISI 304/316 S.S.
0.064" THICK (M304S16GA)


D2196-3

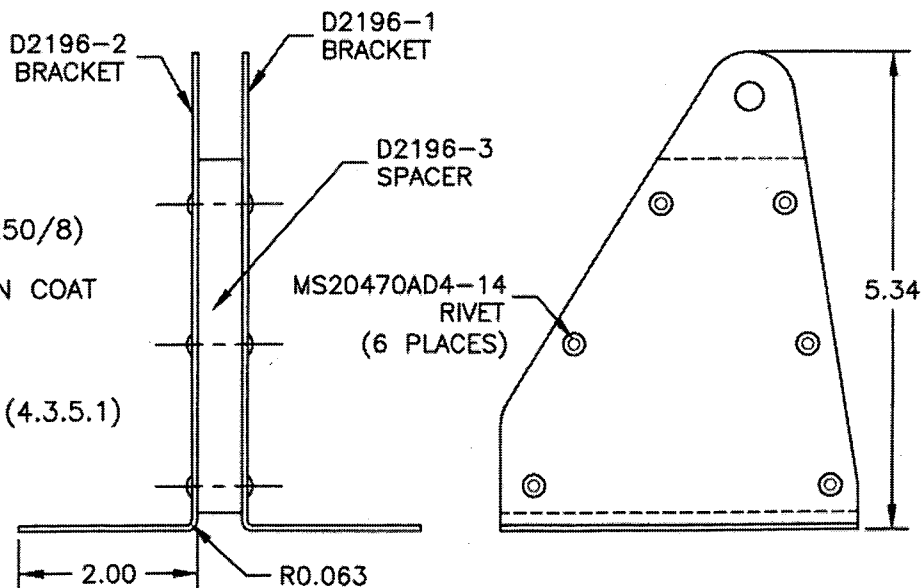
- 2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1

D2196 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER PART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 
- A dimension line with arrows at both ends, indicating a length of 2.00 inches.



D2196 BRACKET
(ASSEMBLY)

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